

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR		
Job Number	: 34254				
Estimate Number	: 12954				
P.O. Number	: <i>N/A</i>	Part Number	: D32597		
This Issue	: 8/23/2007	S.O. No.	: <i>N/A</i>	Drawing Number	: D3259 REV A1
Prsht Rev.	: NC			Project Number	: N/A
First Issue	: <i>N/A</i>	Type	: SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 33677			Material	: <i>N/A</i>
Written By	: <u><i>[Signature]</i></u>	Due Date	: 9/15/2007	Qty:	6 Um: Each
Checked & Approved By	: <u><i>[Signature]</i></u>				
Comment	: Est Rev: A New Issue 07-07-19 JLM	Verified By:	EC		

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 1.4574 sf(s)/Unit Total : 8.7444 sf(s)

2024-T3 .063sheet

Batch: M164921 B07-08-24

20 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3259

Dwg Rev: A1

Prog Rev: A

2-Deburr if necessary

ml 07/08/27/x9)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40 QC8 SECOND CHECK



Comment: SECOND CHECK

En 2/00/28 (x9) *count*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 07.08-30 (19)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: D Date: 27/08/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:48 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR

Job Number: 34254

Part Number: D32597

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PC 7/8/31 (9)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST-176*

*PC 7/8/31 (9)*

8.0

QC21

FINAL INSPECTION W/O RELEASE



*(9)*

Comment: FINAL INSPECTION W/O RELEASE

*PC 7/8/31*

Job Completion



*U 8708-31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

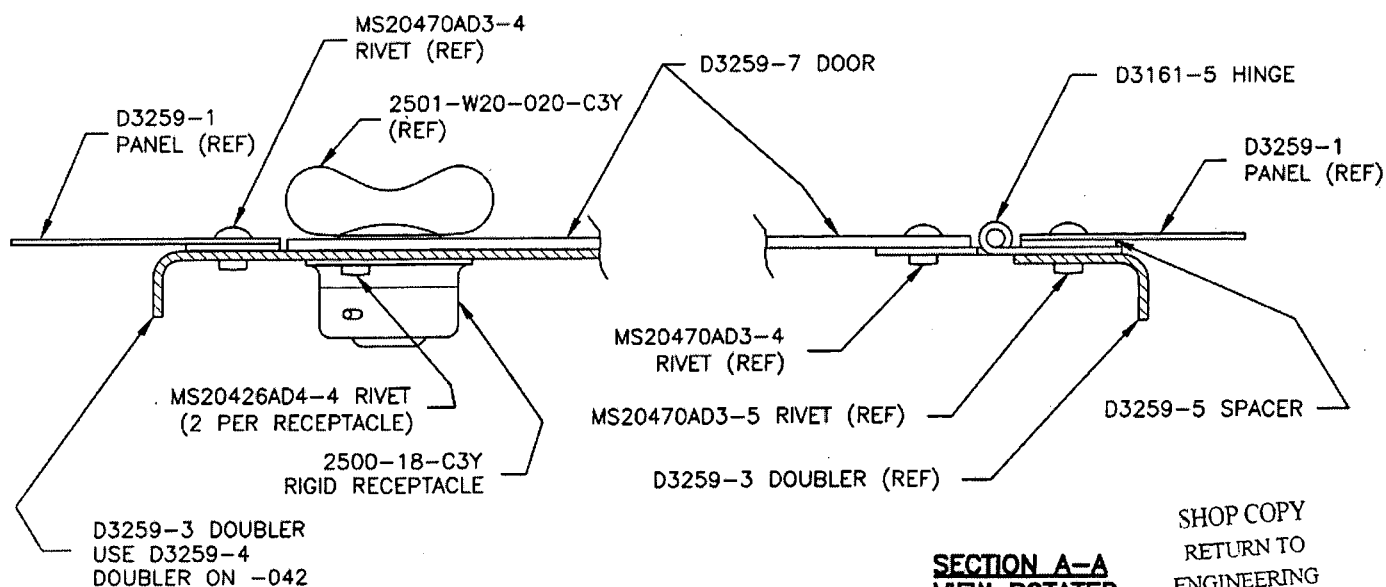
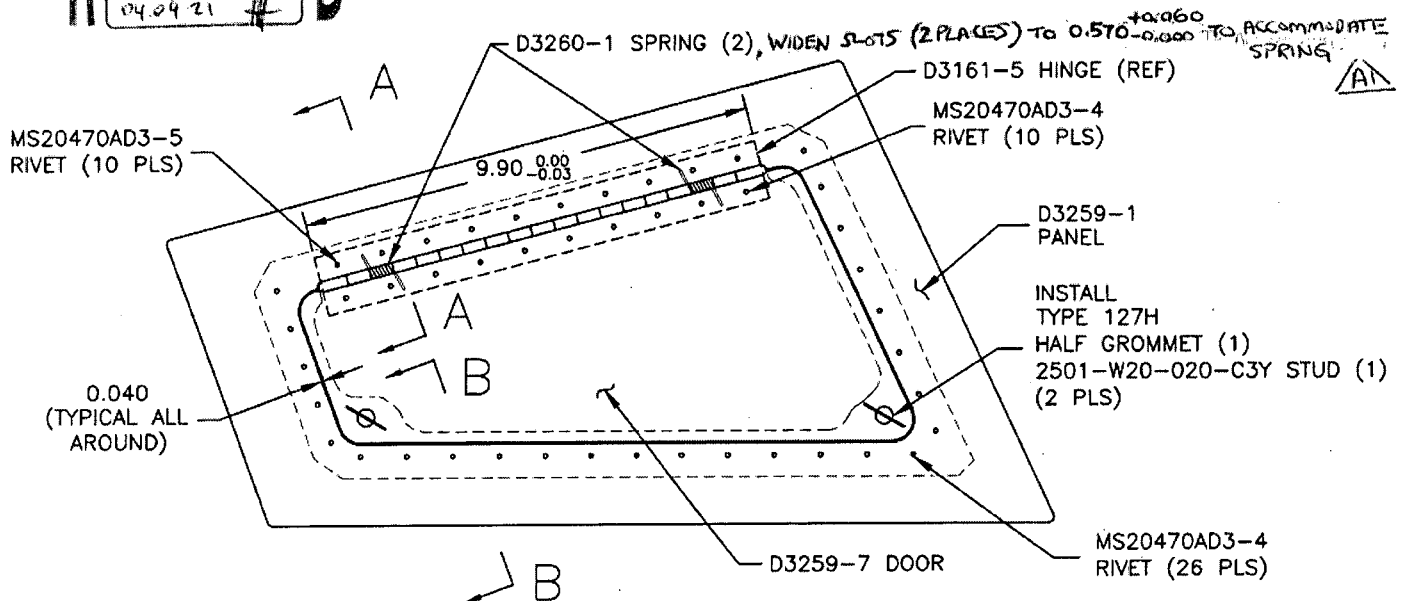
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. A
				D3259	SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE	1:4
A	04.02.25	NEW ISSUE			
AI	CP # 04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING			

RELEASED  
04.04.21 #



**SECTION B-B**  
VIEW ROTATED

**SECTION A-A**  
VIEW ROTATED

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**D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)**  
**D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)**

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

WORK ORDER  
NO. 34254

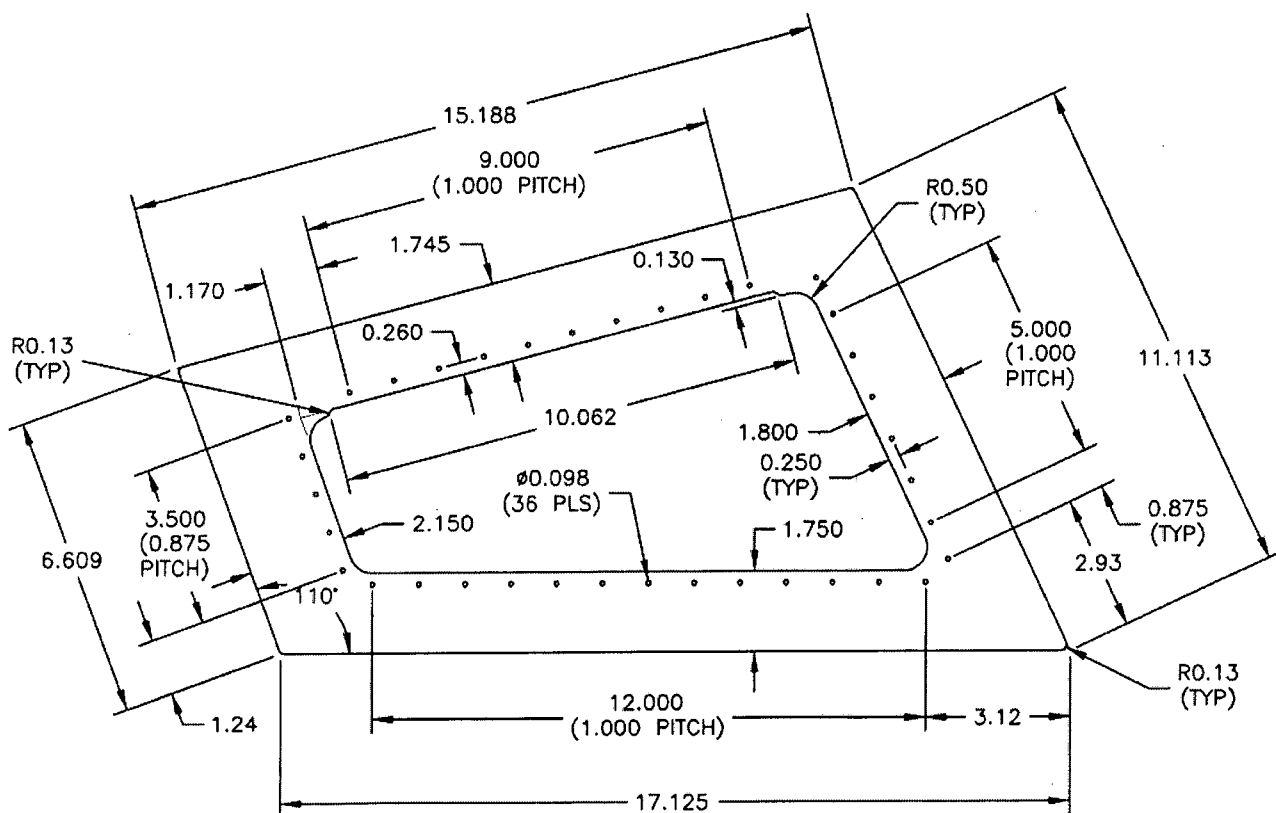
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CHECKED TH	APPROVED TH	DRAWING NO. D3259	REV. A SHEET 2 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.05



### D3259-1 PANEL

#### NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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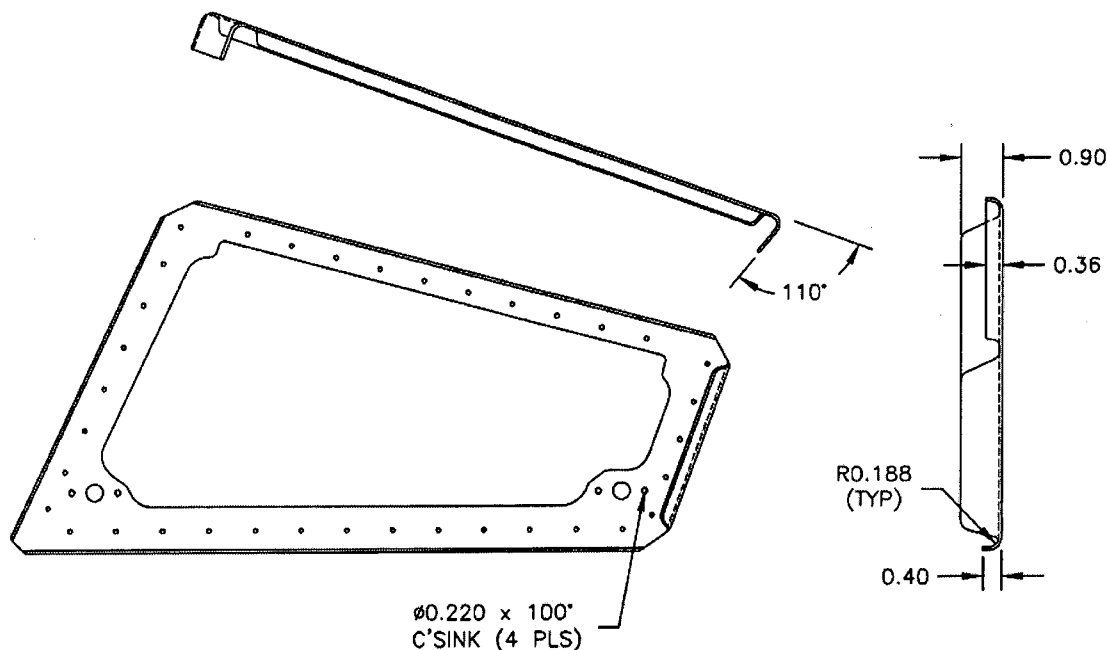
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04.04.14



**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

**D3259-3/-4 NOTES:**

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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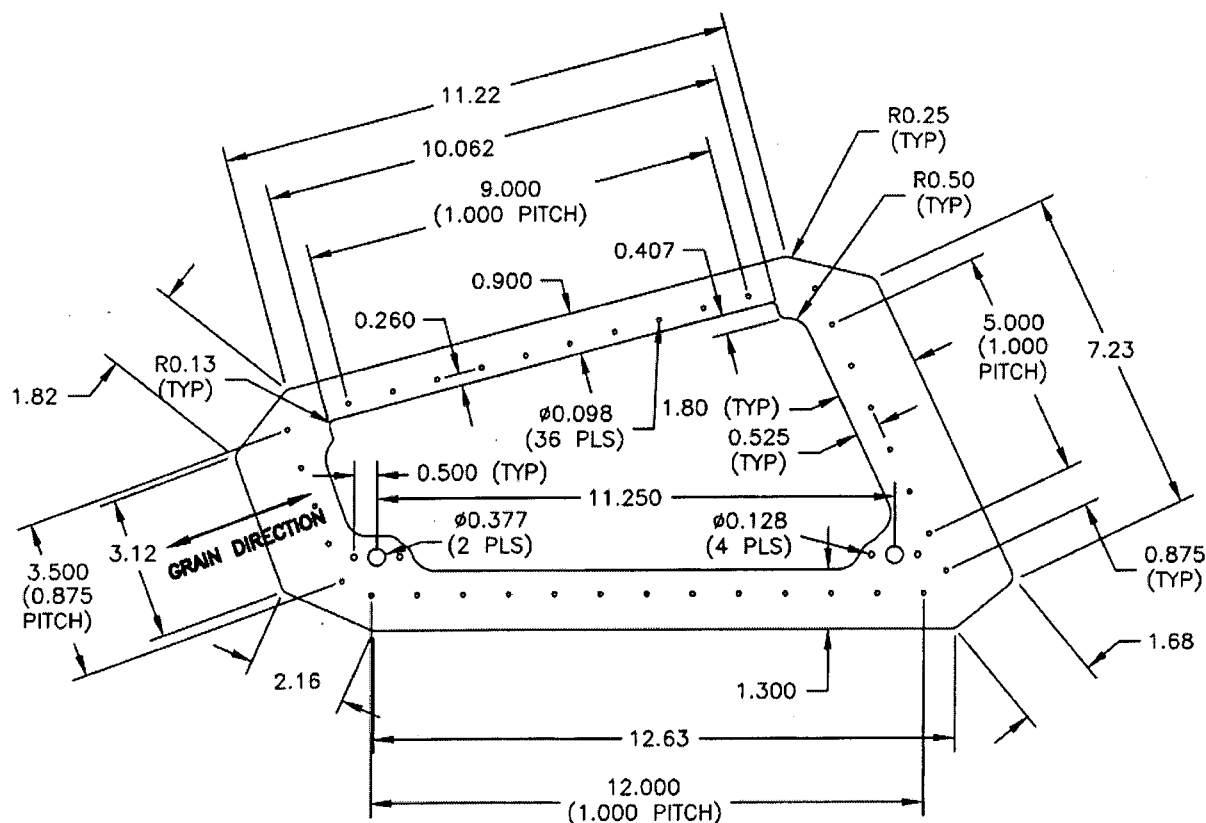
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**D3259-3/-4 DOUBLER FLAT PATTERN**  
( $\phi 0.098$  HOLES TO COINCIDE WITH HOLES IN D3259-1)

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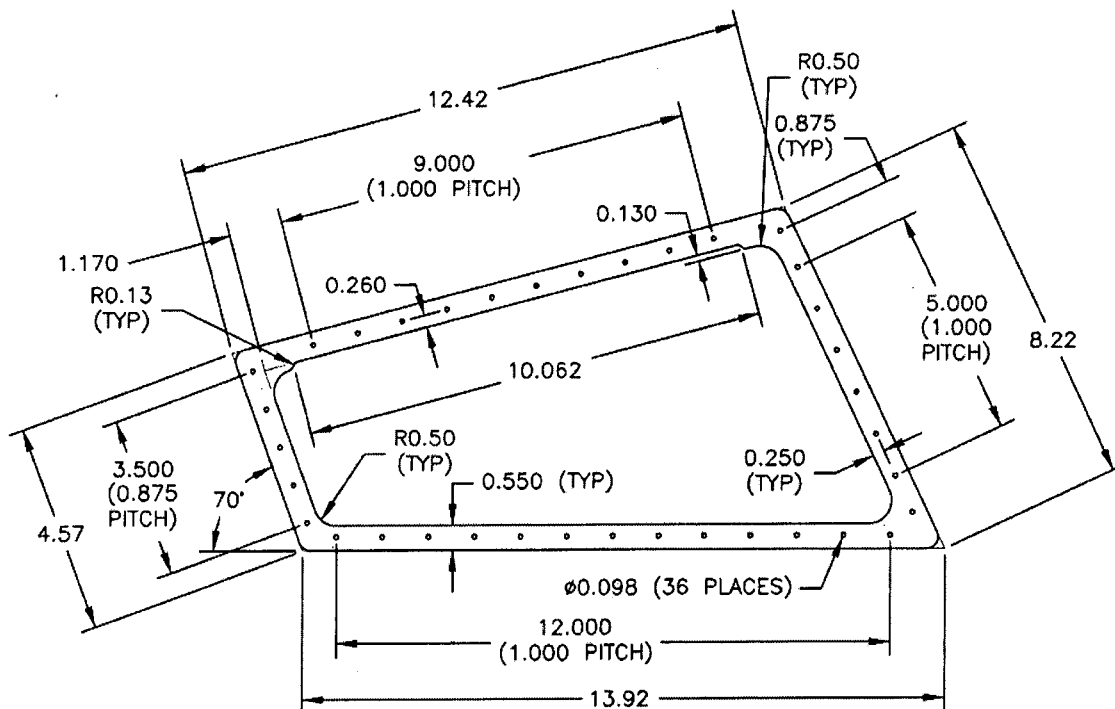
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

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04.04.05 [Signature]



### D3259-5 SPACER

(0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

#### NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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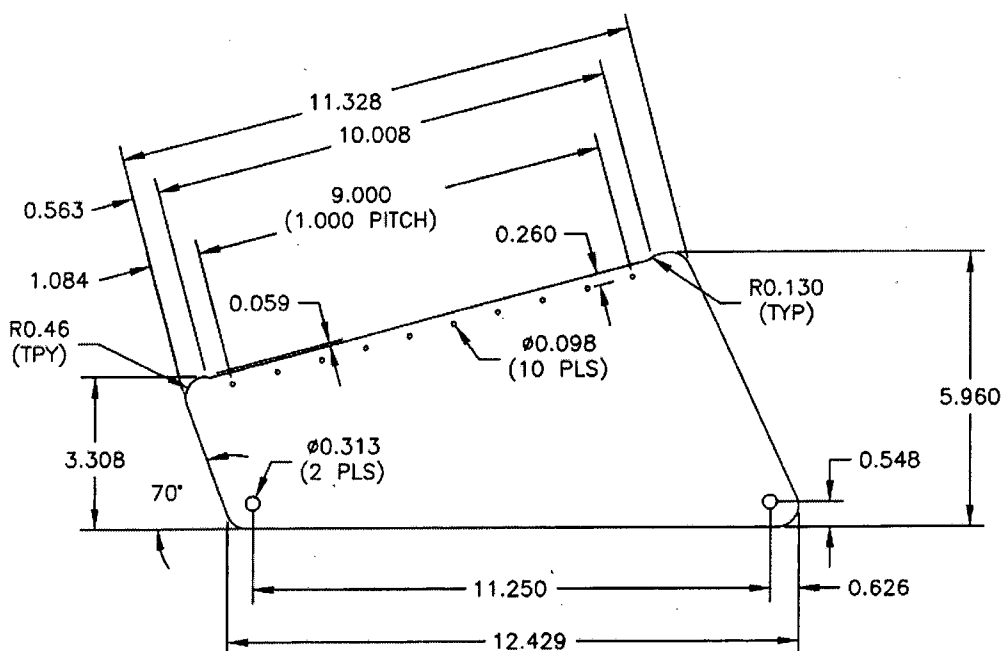
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

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04.04.14 *[Signature]*



**D3259-7 DOOR**

**NOTES:**

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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